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D3728-1**Job Sheet 190337****Part No:** D3728-1**Job Qty:** 10 pcs**Part Name:** Step Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/7/19**Job Tracking No:****Due Date:** 2/25/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV B IPP Rev:A 08-01-30 new issue DD verified by:EC IPP Rev:B 08-02-26 ECN 1140p DD verified by: IPP Rev:C 08-03-19 chg to revB ecn1158 DD verified by:

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1 <i>Omax</i>	10 pcs		2/25/19	0.00	1.29	Waterjet - Flow		<i>ac 19/02/22</i>
110	QC 2	10 pcs		2/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>ac 19/02/22</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

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120	QC 8	10 pcs	2/25/19	0.00 0.00	QC 2 - 66	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	DAS
					QC 8 - 9	40 / DAS
					QC 8 - 68	9-89 9-89
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
130	Small Fab - 2 - B4B	10 pcs	2/25/19	0.00 0.52	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DAS
					Small Fab - 5 - B4B	36
					Small Fab - 6 - B4B	9-89
					Small Fab - 7 - B4B	
140	QC 5	10 pcs	2/25/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	40 / DAS
					QC 5 - 50	9-89 9-89
					QC 5 - 30	
150	Handfinish - 1-1 Chemical-B4B	10 pcs	2/25/19	0.00 0.91	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	DR 19/03/04
					Handfinish - 1 - 11 - B4B	

					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 3	10 pcs	2/25/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
170 Packaging 3-1 - Stock - B4B	10 pcs	2/25/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	

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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
180	QC 21 - SA	10 pcs	2/25/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-Cut as per Dwg D3728 Dwg Rev: B Prog Rev: B 2- Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Small Fab) 1-open holes to finish size as per dwg D3728 2- Deburr if necessary 3- grind water jet marks all around bracket smooth ****do not grind inside where step extrusion goes****
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.250X06.000	6061-T6 Bar .250 X 6.00	12.8420 ft (1.2842 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B0.250X06.000	13	21	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Bracket	0.870inches $\pm$ 0.030	0.900 0.840	Product	
2	Step Bracket	1.400inches $\pm$ 0.030	1.430 1.370	Product	
3	Step Bracket	1.000inches $\pm$ 0.030	1.030 0.970	Product	
4	Step Bracket	1.000inches $\pm$ 0.030	1.030 0.970		
5	Step Bracket	4.250inches $\pm$ 0.030	4.280 4.220		
6	Step Bracket	2.520inches + 0.010 - 0.000	2.530 2.520		
7	Step Bracket	0.250inches $\pm$ 0.030	0.280 0.220		
8	Step Bracket	6.350inches $\pm$ 0.030	6.380 6.320		
9	Step Bracket	0.159inches + 0.005 - 0.001	0.164 0.158		
10	Step Bracket	0.257inches + 0.006 - 0.001	0.263 0.256		
11	Step Bracket	0.440inches $\pm$ 0.010	0.450 0.430		
12	Step Bracket	0.625inches $\pm$ 0.010	0.635 0.615		
13	Step Bracket	0.625inches $\pm$ 0.010	0.635 0.615		
14	Step Bracket	1.250inches $\pm$ 0.010	1.260 1.240		
15	Step Bracket	6.051inches $\pm$ 0.010	6.061 6.041		
16	Step Bracket	2.370inches $\pm$ 0.010	2.380 2.360		
17	Step Bracket	0.440inches $\pm$ 0.010	0.450 0.430		
18	Step Bracket	0.576inches $\pm$ 0.010	0.586 0.566		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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Container No: S155936

Part: D3728-1

Job No: 190337

Serial No/Batch: S155936

Revision:

Inspector:

Exp Date:

Instructions:

Various STC's

Date: 02/23/19